

Date: Monday, 6/25/2007 9:10:06 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 33112		
Estimate Number	: 10437		
P.O. Number	: <i>NIA</i>	Part Number	: D33191
This Issue	: 6/25/2007	Drawing Number	: D3319 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i>	Drawing Revision	: B
Previous Run	: 32105	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/10/2007
Checked & Approved By	: <i>[Signature]</i> 07.06.25	Qty:	10 Um: Each
Comment	Est: B 06.10.14 Added step 9, dwg rev B KJ/EC Est Rev:C Now on Waterjet 06-10-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
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Comment: Qty.: 0.6594 sf(s)/Unit Total: 6.5940 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: *M104401*

IB 27-06-07

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: *B*

Prog Rev: *B*

IB 27-06-07

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07/06/07

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 07/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33112

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SIB 07/07/17

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SA 07/07/17 (X10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: —

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M103551

M104721

88 07/07/19

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/07/19 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/07/20

(10X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/07/20

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: _____

07/07/24 (10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/01/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33112

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
2/21/24

Job Completion



W 2/21/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33112
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

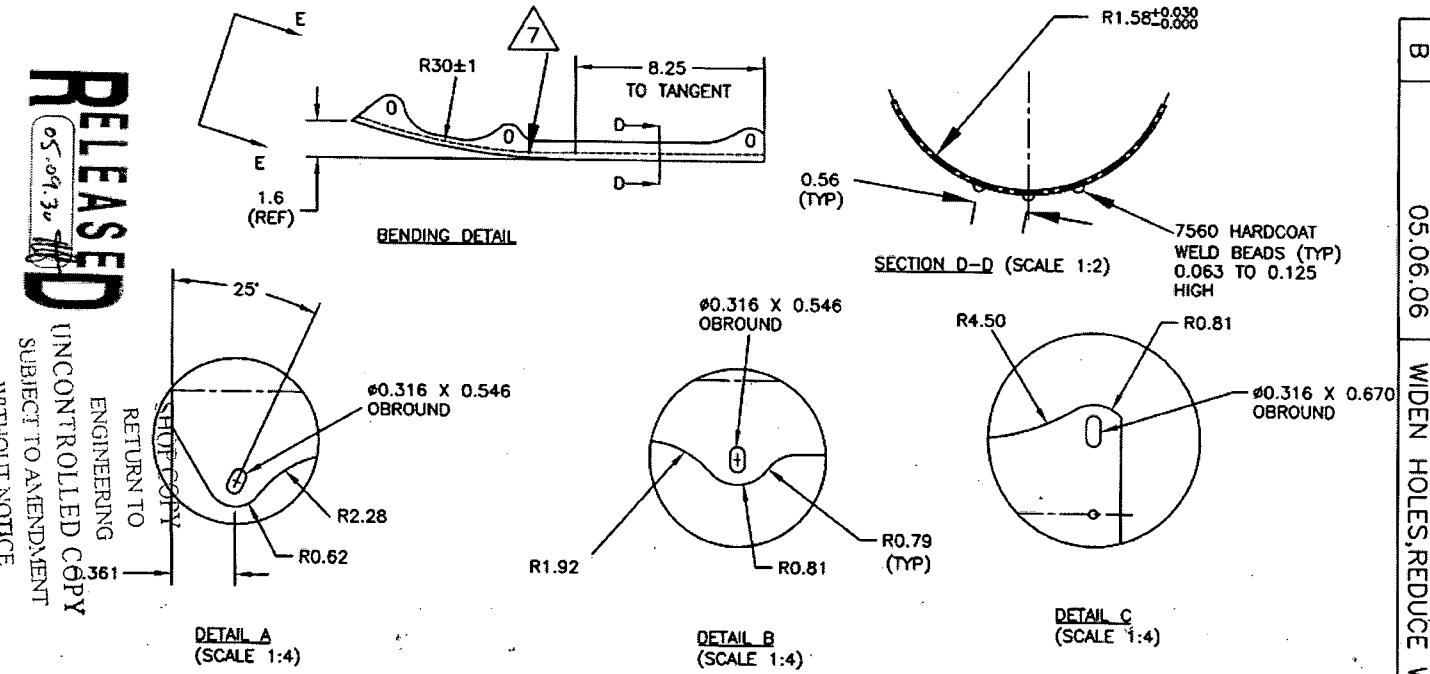
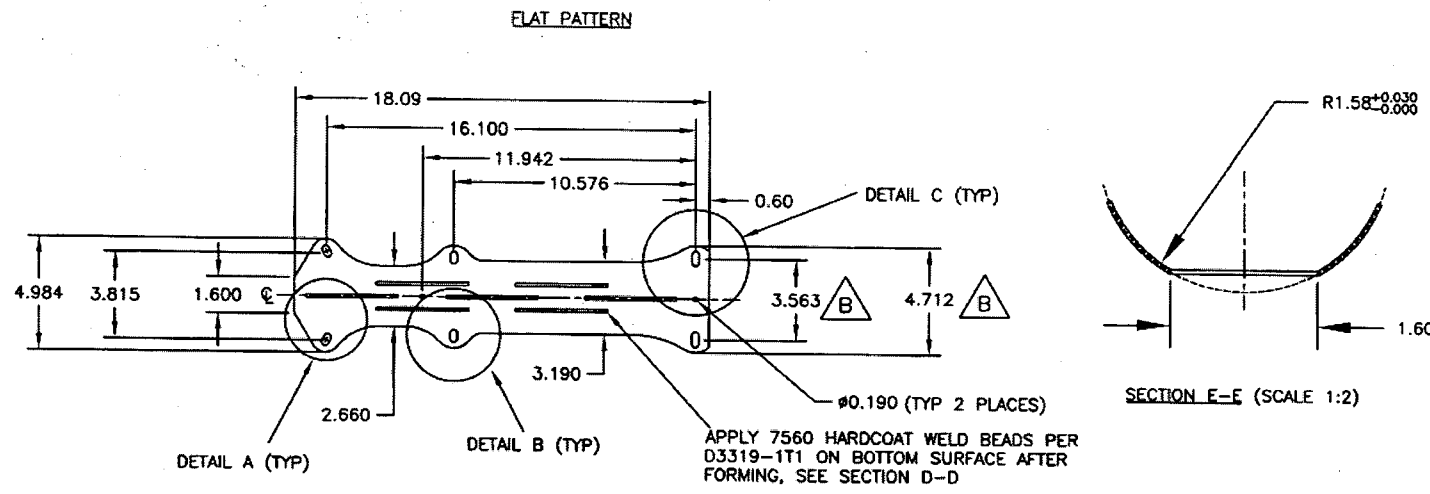
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.985	✓		VERN	
1.600	+/-0.010	1.600	✓		VERN	
2.660	+/-0.010	2.670	✓		VERN	
3.190	+/-0.010	3.200	✓		VERN	
3.563	+/-0.010	3.562	✓		VERN	
4.712	+/-0.010	4.712	✓		VERN	
0.60	+/-0.030	.61	✓		VERN	
10.576	+/-0.010	10.58	✓		VERN	
11.942	+/-0.010	11.949	✓		VERN	
18.09	+/-0.030	18.10	✓		M.T.	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	316 x .547	✓		VERN	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	316 x .672	✓		VERN	
Ø0.190	+0.005/-0.001	.191	✓		VERN	

Measured by:	IB / MM	Audited by:	ES	Prototype Approval:	N/A
Date:	27-06-07	Date:	07/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	JA



DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	P41	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D3319.
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8



- D3319-1 WEARPLATE
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) PART IS SYMMETRICAL ABOUT CENTERLINE
 - 5) ALL DIMENSIONS IN INCHES
 - 6) WELD PER DART QSI 004
 - 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-09-30
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

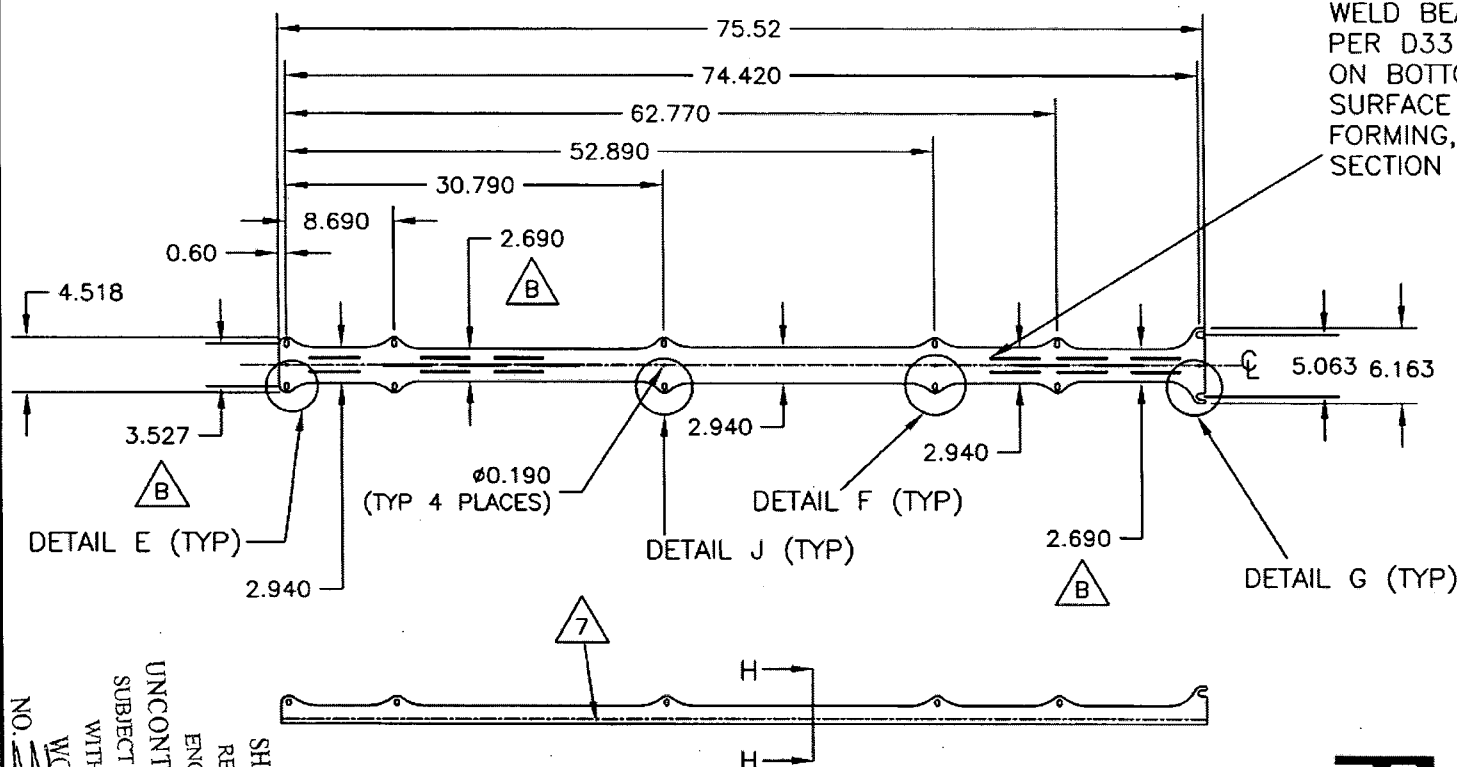
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

RELEASED
05.09.30

FLAT PATTERN



BENDING DETAIL

D3319-3 WEARPLATE

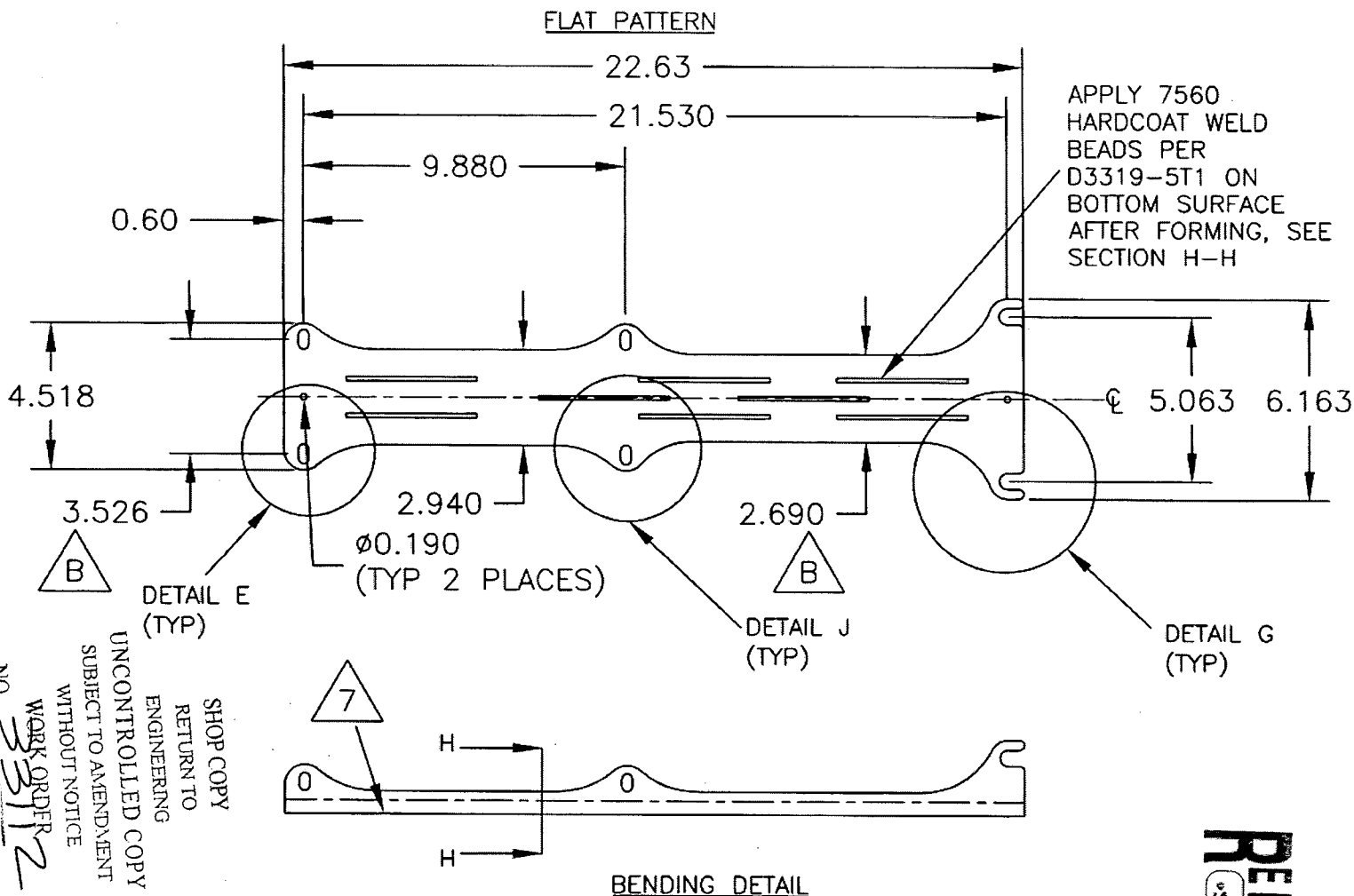
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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WORK ORDER
NO. 3312

DART

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 3 OF 5
	TITLE	SCALE
	WEARPLATE	1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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05.06.30

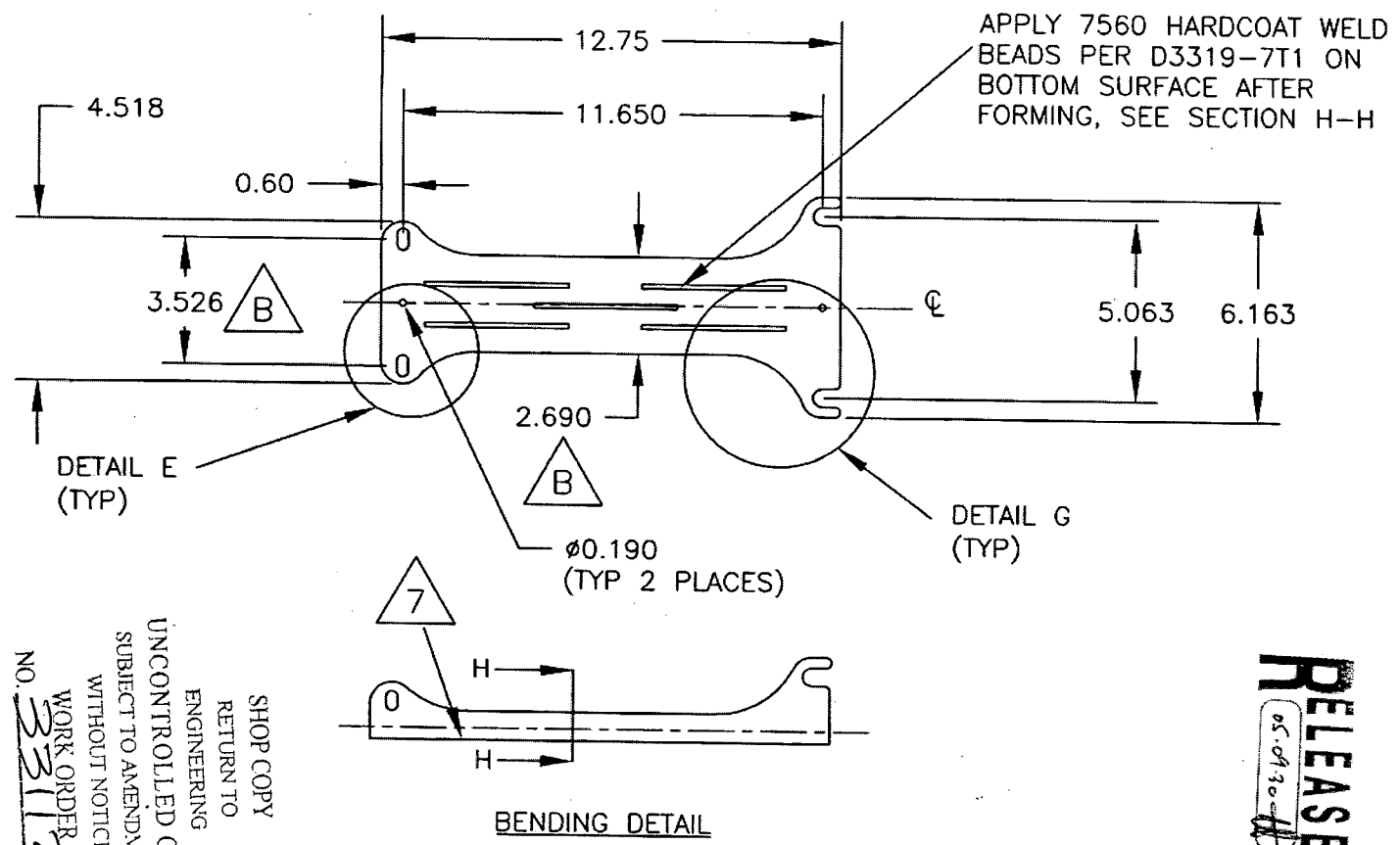
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3312
WORK ORDER
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DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3319	SHEET 4 OF 5
		SCALE	1:5	

RELEASED
05.09.10-11

FLAT PATTERN



D3319-7 WEARPLATE

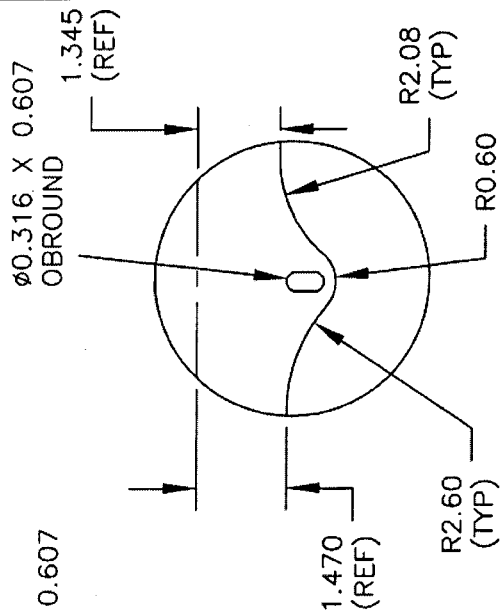
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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WITHOUT NOTICE
WORK ORDER
NO. 33112

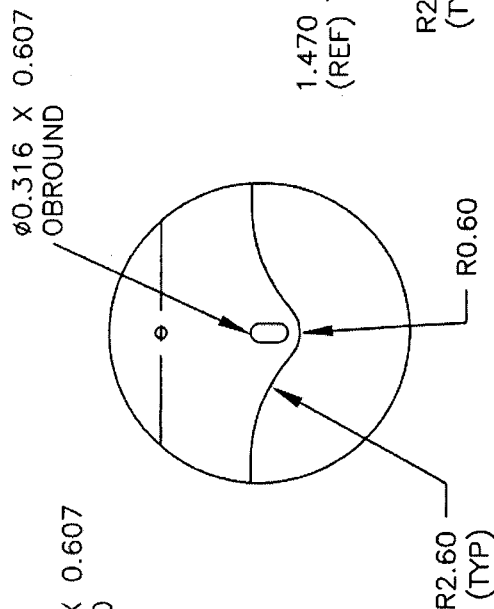


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

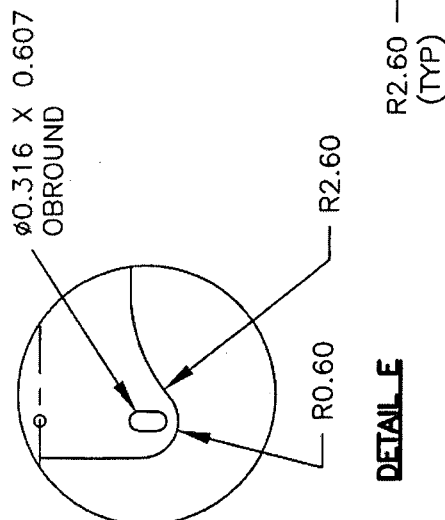
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05-09-30



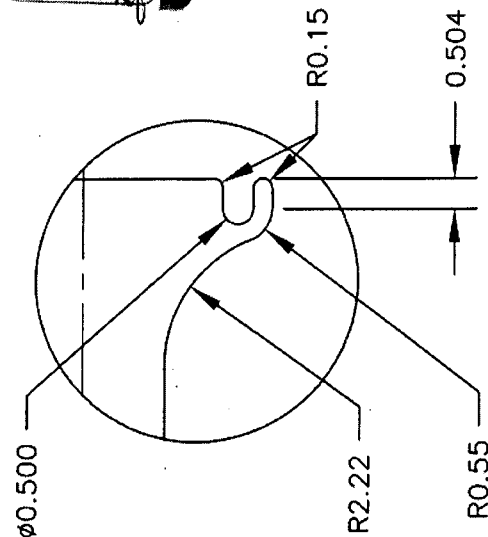
DETAIL J



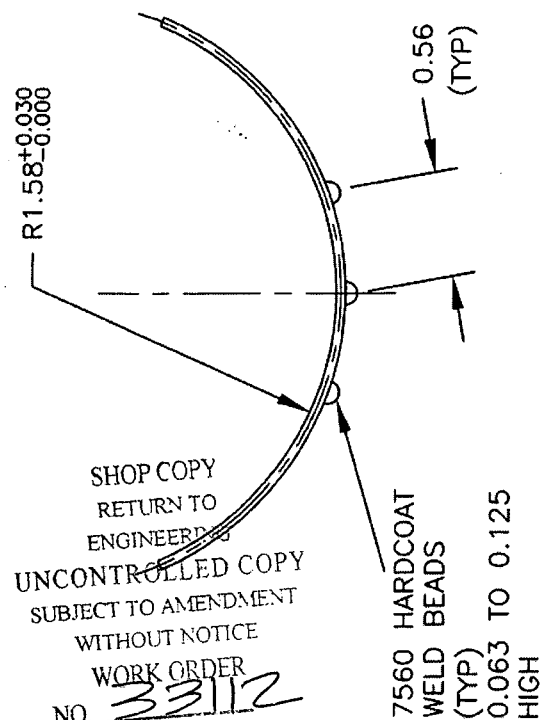
DETAIL F



DETAIL E



DETAIL G



**SECTION H-H
(SCALE 1:1)**

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NO. 33112

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